



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2891-1

Job Sheet 195399



Part No: D2891-1

Job Qty: 6 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *STK*

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified: DD IPP Rev:E 11.08.04 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	6/14/19		0.00	4.92	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	6 pcs	6/14/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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Container No: S190655



Part: D2891-1

Job No: 195399

Serial No/Batch: S190655

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/14/19

120	QC 8	6 pcs	6/14/19	0.00 0.00	QC 2 - 8		DAS 64 9-89
					QC 2 - 66		
					QC 2 - 64	2019/06/14	
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 8 - 12		
					QC 8 - 14	2019/06/14	
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8		
					QC 8 - 9		
					QC 8 - 68		
					QC 8 - 67		
130	Crosstubes - 2 - B4B	6 pcs	6/14/19	0.00 0.28	QC 8 - 1 (A)		
					QC 8 - 47		
					QC 8 - 40		
					QC 8 - 52		
140	QC 3	6 pcs	6/14/19	0.00 0.00	QC 8 - 23		
					Crosstubes - 1 - B4B	RD 19-6-18	
					Crosstubes - 2 - B4B		
					Crosstubes - 3 - B4B		
					Crosstubes - 4 - B4B		
					QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40	JUN 19 2019	
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
170	Packaging 3-1 - Stock - B4B	6 pcs	6/14/19	0.00 0.00	QC 3 - 9		DAS 40 9-89
					Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	6 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 8176225

140 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: LOCATION : LG052

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK076	3	5	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches $\pm$ 0.000	0.000 0.188		
2	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240		
3	2.250 Support	0.115Inches $\pm$ 0.000	0.000 0.115		
4	2.250 Support	0.040Inches $\pm$ 0.000	0.000 0.040		
5	2.250 Support	0.010Inches $\pm$ 0.000	0.000 0.010		
6	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240		
7	2.250 Support	0.290Inches $\pm$ 0.000	0.000 0.290		
8	2.250 Support	0.115Inches $\pm$ 0.000	0.000 0.115		
9	2.250 Support	0.454Inches $\pm$ 0.000	0.000 0.454		
10	2.250 Support	2.779Inches $\pm$ 0.000	0.000 2.779		
11	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240		
12	2.250 Support	1.002Inches $\pm$ 0.000	0.000 1.002		
13	2.250 Support	0.053Inches $\pm$ 0.000	0.000 0.053		
14	2.250 Support	0.257Inches $\pm$ 0.000	0.000 0.257		
15	2.250 Support	1.663Inches $\pm$ 0.000	0.000 1.663		
16	2.250 Support	0.053Inches $\pm$ 0.000	0.000 0.053		
17	2.250 Support	0.022Inches $\pm$ 0.000	0.000 0.022		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	195399
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.188	.188	.189	.189	.189
AB	0.240	0.260		.247	.246	.244	.245	.242
AC	0.115	0.150		.123	.123	.125	.125	.124
AD	0.040	0.060		.051	.051	.050	.051	.052
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AG	0.290	0.310		.295	.295	.300	.300	.302
AH	0.115	0.150		.135	.136	.136	.136	.135
AI	0.454	0.474		.465	.466	.464	.464	.465
AJ	2.779	2.789		.2781	.2781	.2783	.2783	.2782
AK	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AL	1.002	1.042		1.039	1.039	1.036	1.036	1.027
AM	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AN	0.257	0.262		.260	.260	.260	.260	.260
AO	1.663	1.683		1.675	1.675	1.674	1.674	1.674
AP	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AQ	0.022	0.042		R.032 ok	R.032 ok	R.032 ok	R.032 ok	R.032 ok
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	2019/06/14
Audited by:	<i>[Signature]</i>	Date:	19/06/14
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	195399
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.1890				
AB	0.240	0.260		.243				
AC	0.115	0.150		.124				
AD	0.040	0.060		.051				
AE	0.010	0.020		.010				
AF	0.240	0.260		R. 250 OK				
AG	0.290	0.310		.300				
AH	0.115	0.150		.135				
AI	0.454	0.474		.465				
AJ	2.779	2.789		2.782				
AK	0.240	0.260		R. 250 OK				
AL	1.002	1.042		1.037				
AM	0.053	0.073		R. 063 OK				
AN	0.257	0.262		.260 Ø				
AO	1.663	1.683		1.674				
AP	0.053	0.073		R. 063 OK				
AQ	0.022	0.042		R. 032 OK				
AR								
AS								
AT								
Accept/Reject								

Measured by: *MLL* **Date:** 2019/06/14

Audited by: *SMK* **Date:** 19/06/14

Preliminary Approval: **Date:**

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